

# Work Order ID 85715

**\*85715\***

Page 1

June-14-12 8:29:19 AM

Item ID: D3929-041

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Gusset Assembly

Start Date: 14/06/2012 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 20/06/2012 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/14 Tooling:

Date:

Run Start **\*NR1\***

QC:

Date: 12/06/14 SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3929

Rev A

100

0.00

**\*100\***

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3929

Dwg Rev: A

Prog Rev: A

304 .125"

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*110\***

QC

Memo

0.00

Quality Control

6 0 Jm  
12-6-14

6 0 Jm  
12-6-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 85715

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Cust Item ID:

Required Date: 20/06/2012 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00

**\*120\***

QC

Memo

0.00

*8/20/15*

*(76)*

Quality Control

140

0.00

**\*140\***

Large Fab

Memo

0.00

Weld bushings D3907-1 as per dwg D3929

316L rod batch: *4118161*

*(6x)*

*12.06.19*

Large Fab

150

QC9- Inspect visual per QS1004- Fusion Welds

0.00

**\*150\***

QC

Memo

0.00

*6x*

*12.06.20*

Quality Control

W/O:		WORK ORDER CHANGES					
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# Work Order ID 85715

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Page 3

June-14-12 8:29:19 AM

Item ID: D3929-041

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**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Gusset Assembly

Start Date: 14/06/2012 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 20/06/2012 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Run Start

**\*NR1\***

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

**\*NR2\***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

**\*160\***

QC

Memo

0.00

Quality Control

6

W 12.06.20

170

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00

**\*170\***

Packaging

Memo

0.00

Packaging

(6x)

SS 12.06.19

180

QC21- Final Inspection - Work Order Release

0.00

**\*180\***

QC

Memo

0.00

Quality Control

12/6/20

MLJ 12/6/20

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

# Picklist Print

June-14-12 8:29:23 AM

Page 1

Work Order ID: 85715

**\*85715\***

Parent Item: D3929-041

**\*D3929-041\***

Parent Item Name: Gusset Assembly

Start Date: 14/06/2012

Required Date: 20/06/2012

Start Qty: 6.00

Required Qty: 6.00

## Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S11GA

Purchased

No

100

sf

102.3760

0.45

2.842105

\*\*

**\*M304S11GA\***

304/316 0.125 Sheet

Jm  
12-6-14

### Location

### Loc Qty

### Loc Code

MAT020

102.376

121380

24.9

121780

77.476

~~121780~~

✓D3907-1

Manufactured

No

130

Each

63.0000

2

12

\*\*

**\*D3907-1\***

Bushing

SL 12.06.20

### Location

### Loc Qty

### Loc Code

WA

63

81470

23

82786

40

11x  
1x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

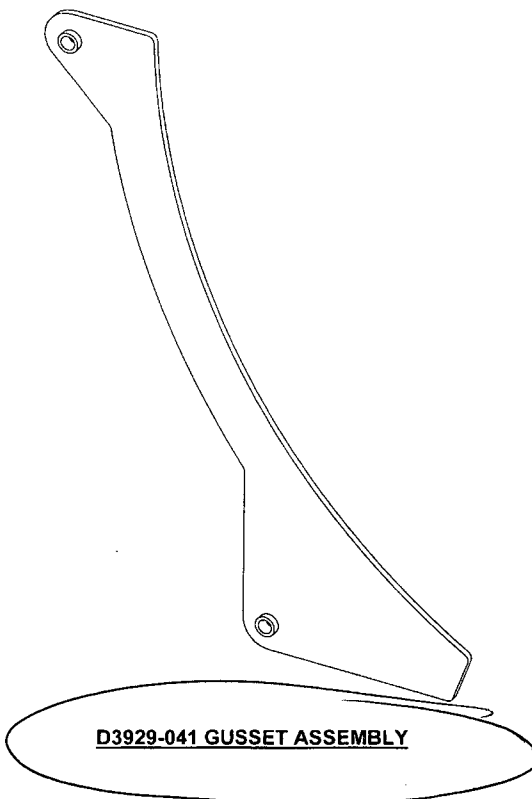
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

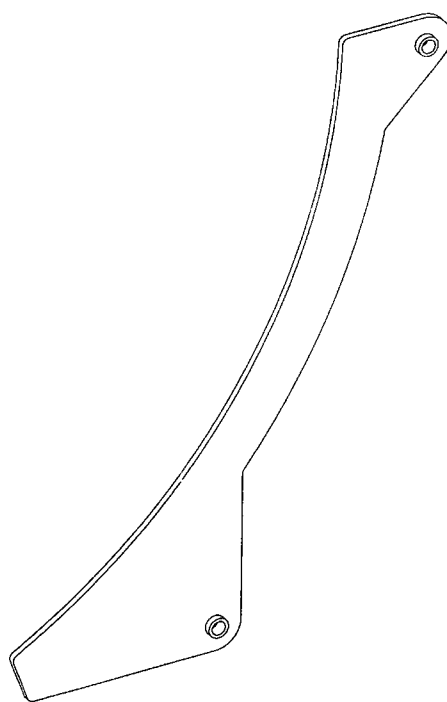
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**NOTE:** Date & initial all entries

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3929-041	GUSSET ASSEMBLY
2		X	D3929-042	GUSSET ASSEMBLY
11	2	2	D3907-1	BUSHING
12	1	1	D3929-1	SUPPORT GUSSET



D3929-041 GUSSET ASSEMBLY



D3929-042 GUSSET ASSEMBLY

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 85715 MLC

12/06/14

RELEASED  
9/24/12 MJD

- NOTES:  
1) MATERIAL: N/A  
2) FINISH: N/A  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER  
7) WEIGHT: 0.73 lbs EACH  
8) WELDING: PER DART QSI 004

A	NEW ISSUE		MB	09.04.03
REV.		DESCRIPTION	BY	DATE
DESIGN				
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	09.04.03			

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3929** REV. A  
SHEET 1 OF 3

TITLE **GUSSET ASSEMBLY** SCALE  
NTS

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**Dart Aerospace Ltd**

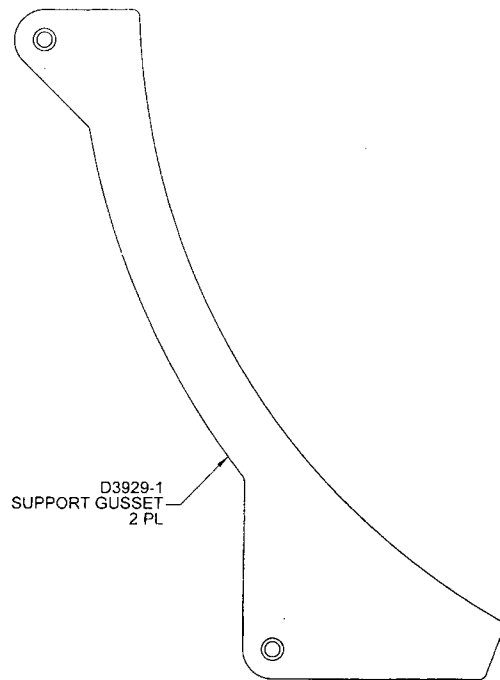
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

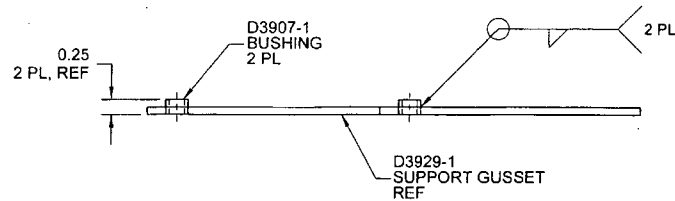
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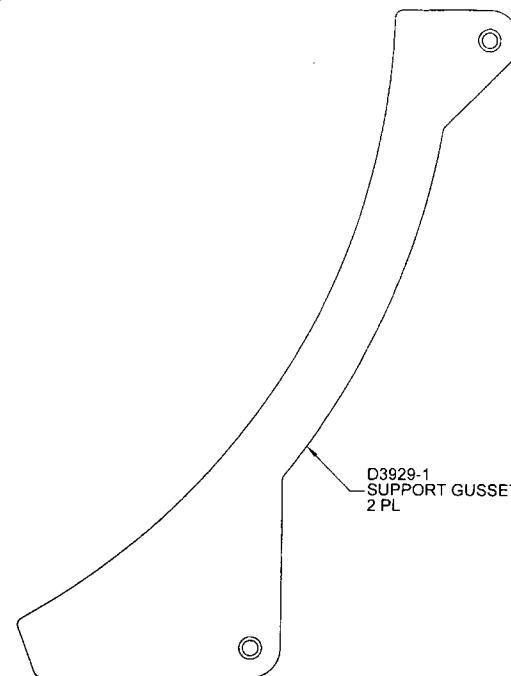
**NOTE:** Date & initial all entries



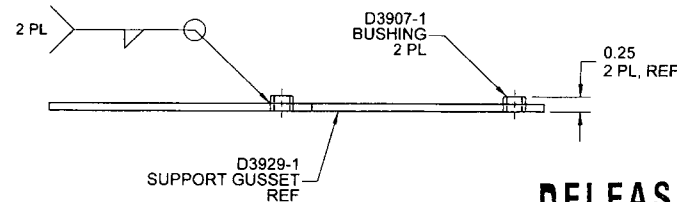
D3929-1  
SUPPORT GUSSET  
2 PL



D3929-041 GUSSET ASSEMBLY



D3929-1  
SUPPORT GUSSET  
2 PL



D3929-1  
SUPPORT GUSSET  
REF

D3929-042 GUSSET ASSEMBLY

**RELEASED**  
09/04/27

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3929	SHEET 2 OF 3
APPROVED		TITLE	SCALE
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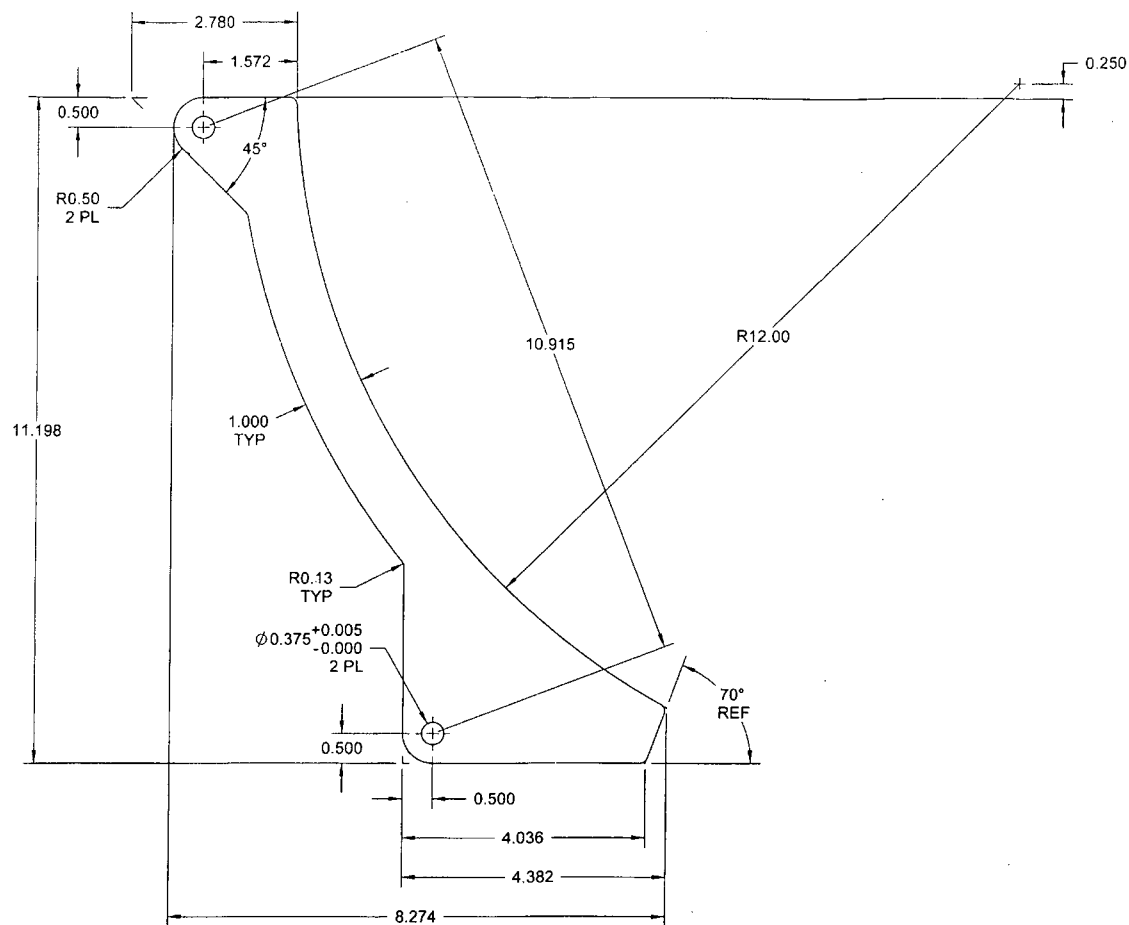
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**NOTE:** Date & initial all entries



**D3929-1 SUPPORT GUSSET**

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524  
11 GAUGE (0.125 THICK)  
REF. DART SPEC. M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.72 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3929	REV. A
MFG. APPR.			SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		GUSSET ASSEMBLY	NTS
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**RELEASED**  
09/04/22

25715

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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